

Work Order ID 158759

Thursday, March 30, 2017 3:56:07 PM

158759

Page 1

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 3/31/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/9/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULED/S
Approvals: Process Plan: DAS 21 9-89 Date: MAR 31 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.88							
FLOW CNC Waterjet	1-Cut as per Dwg D3319 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.10							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.20							
Quality Control									

DAS
38
9-89
APR 04 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

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Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 3/31/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/9/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC	NC BRAKE	0.07			DAS 30 9-89	10			APR 04 2017
Brake NC	Memo 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>C</u> 2- Form flat on press using DT8776 block	0.50							
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00				10			DAS 38 9-89
Quality Control	Memo	0.20							APR 04 2017
160 *160* Large Fab	Weld per dwg A/R Hardcoat steel Batch: <u>M136417</u>	0.00				10	12	17-45	
Large Fab	Memo 1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: <u>C</u> Qty Part Number Description Batch A/R N/A 228/7560 Hardcoat Rod <u>C</u>	1.90							

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 3

Item ID: D3319-1 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Forward Wearplate
Start Date: 3/31/2017 **Start Qty:** 10.00 ***10*** **Cust Item ID:**
Required Date: 4/9/2017 **Req'd Qty:** 10.00 ***10*** **Customer:**
Reference: SCHEDULED/S

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00				10			DAS 38 9-89 APR 05 2017
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00				10			DAS 38 9-89 APR 05 2017
180									
QC	Memo	0.20							
Quality Control									
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
190	M 134858								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3.20								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 3.50								
						10			1704-6 38 9-89

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 3/31/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/9/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<u>10</u>			DAS 38 9-89 APR 07 2017
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST603</u> Packaging Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-1, B/N: BXXXXXFor Product Eligibility see PDA05-18 and Stock Location: _____	0.00 0.10			DAS 6 9-89	<u>10</u>			DAS 41 9-89 APR 08 2017
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00						<u>17/4/11</u>	DAS 21 9-89 APR 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Work Order ID: 158759

158759

Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 3/31/2017

Required Date: 4/9/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	67.0000	0.628	6.610526		DAS 46 9-89	
M1010S18GA									**			17/04/02	

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT019

66.999952

m136340

10

m136896

25

m137041

32

7.3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 158759
Description: Wearplate		Part Number: D3319-1
Inspection Dwg: D3319	Rev: C	Page 1 of 1

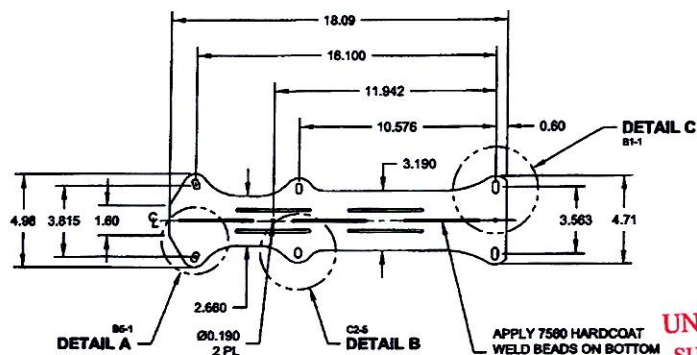
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.984	✓		Dr. 01	
1.600	+/-0.010	1.60	✓		Tape	
2.660	+/-0.010	2.667	✓			
3.190	+/-0.010	3.198	✓			
3.563	+/-0.010	3.561	✓			
4.71	+/-0.030	4.713	✓			
0.60	+/-0.030	0.603	✓			
10.576	+/-0.010	10.577	✓			
11.942	+/-0.010	11.942	✓			
18.09	+/-0.030	18.09	✓			
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	0.318 x 0.547	✓			
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	0.317 x 0.673	✓			
Ø0.190	+0.005/-0.001	0.193	✓			
3.815	+/-0.010	3.815	✓			
16.100	+/-0.010	16.100	✓			

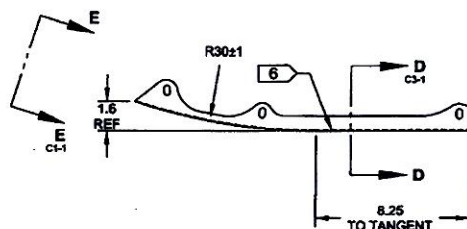
DAS
46
9-89

Measured by:	Audited by: DAS 38	Preliminary Approval:
Date: 17/04/02	Date: APR 04 2017	Date:

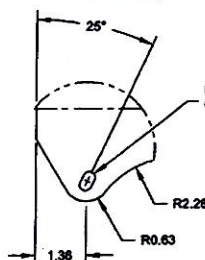
Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



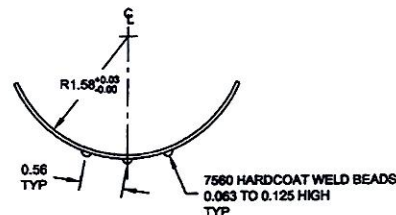
D3319-1F FLAT PATTERN



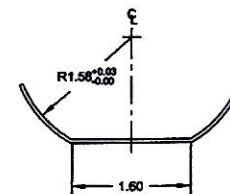
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



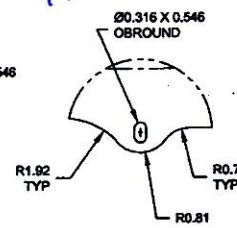
DETAIL A
SCALE 4X



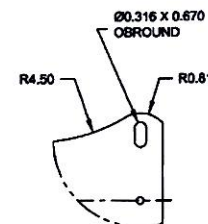
SECTION D-D
SCALE 4X



SECTION E-E
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158759 *MW*
1703-31

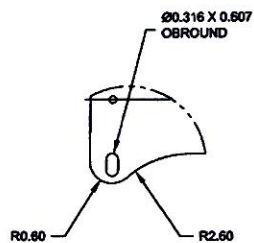
D3319-1 WEARPLATE

NOTES:

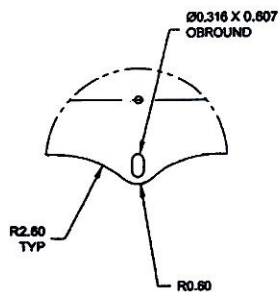
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-946 12-3-16

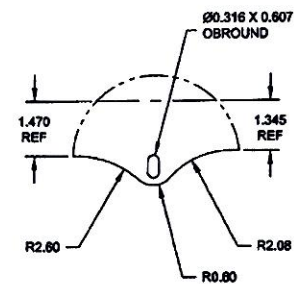
C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/4-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/4-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NT
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED BY DART AEROSPACE LTD. AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL USE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



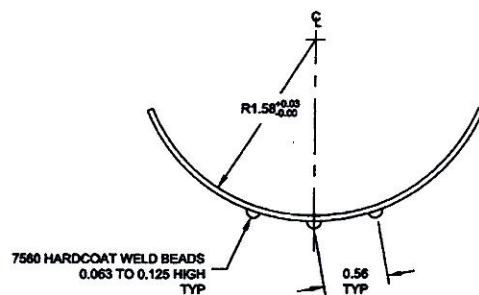
DETAIL K
SCALE 2X
B6-2
C4-3
C8-3



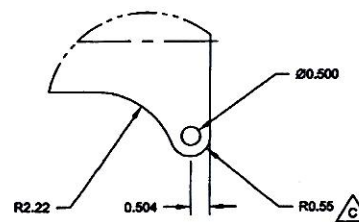
DETAIL F
SCALE 2X
B6-2



DETAIL J
SCALE 2X
B6-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B6-2
C3-3
C8-3

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